

Date: Wednesday, 3/14/2007 12:25:36 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPLATE		
Job Number	: 31194		Part Number	: D33191		
Estimate Number	: 10437		Drawing Number	: D3319 REV. B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 3/14/2007 S.O. No. : N/A		Drawing Revision	: B		
Prsh Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 3/30/2007 Qty: 8 Um: Each		
Previous Run	: 30904					
Written By						
Checked & Approved By						
Comment	: Est: B 05.10.14 Added step 9, dwg rev B Est Rev.C Now on Waterjet 06-10-26 JLM			KJ/EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S18GA	1010/1025/A21/6aA SHEET .048
Comment: Qty.: 0.6594 sf(s)/Unit Total : 5.2752 sf(s) 1010/1025/A21/6aA SHEET .048 Batch: M103676(6) M10287(2)		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3319 Dwg Rev: B Prog Rev: B		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Ship 23-24/05

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: WEARPLATE
Job Number: 31194		Part Number: D33191
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	BRAKE NC	NC BRAKE 
Comment: NC BRAKE		1- Form using DT8326 & DT8261 as per Dwg D3319 Rev: <u>3</u> 2- Form flat on press using DT8776 block
7.0	QC6	DIMENSIONAL CHECK  <u>0705-16 (8)</u> 
Comment: DIMENSIONAL CHECK		
8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 
Comment: LARGE FABRICATION RESOURCE 1		1- Layout weld location as per Dwg D3319 using Jig D3319-1T3 2- Weld hard surface using D3319-1T2 per QSI 004 and Dwg D3319 Rev: <u>11</u> Qty Part Number Description Batch A/R N/A 7560 Hardcoat Rod <u>103551</u>
9.0	QC9	VISUAL WELDING INSPECTION 
Comment: VISUAL WELDING INSPECTION		<u>107/05/23 (8)</u>
10.0	POWDER COATING	POWDER COATING  <u>M101601</u> 
Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3		<u>07-05-24 (8)</u>
11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT		<u>07/05/24 (8)</u>
12.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-1, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock: Location: <u>ST 342</u>		<u>3/15/24 (8)</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 27/5/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/14/2007 12:25:36 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 31194

Part Number: D33191

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(8)

Comment: FINAL INSPECTION/W/O RELEASE

3/14/2007

Job Completion



3/14/2007

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

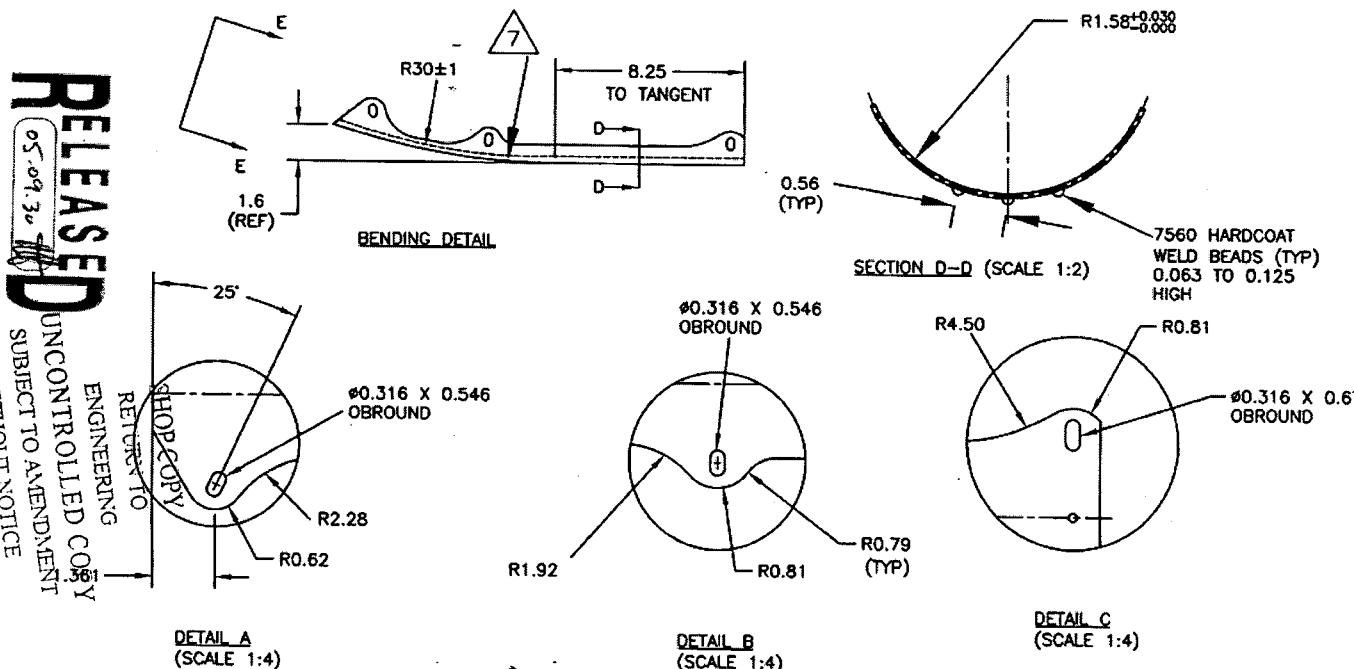
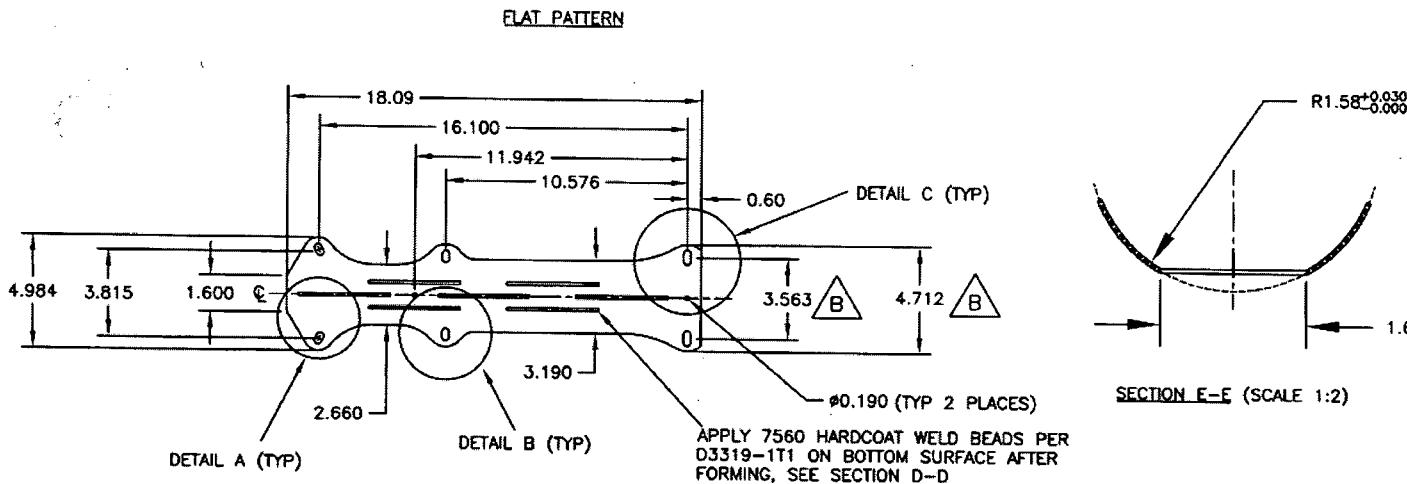
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN P41	DRAWN BY P44	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3319
DATE 05.06.06	TITLE WEARPLATE	SCALE 1:8
A B	04.09.24 05.06.06	NEW ISSUE WIDEN HOLES, REDUCE WIDTH -3/-5/-7

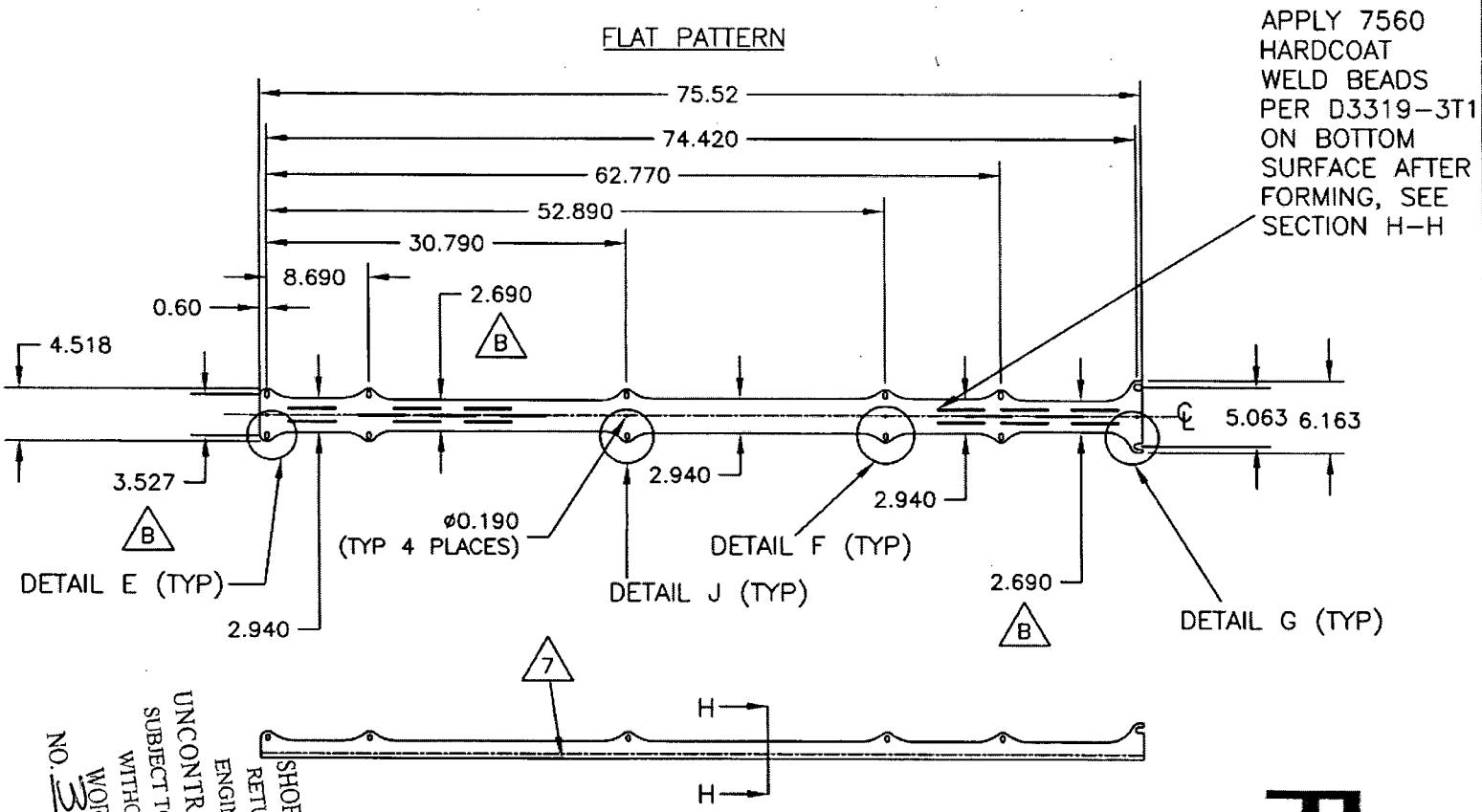


D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

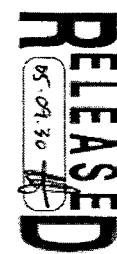
NO. 31941
WORK ORDER

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE



D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"



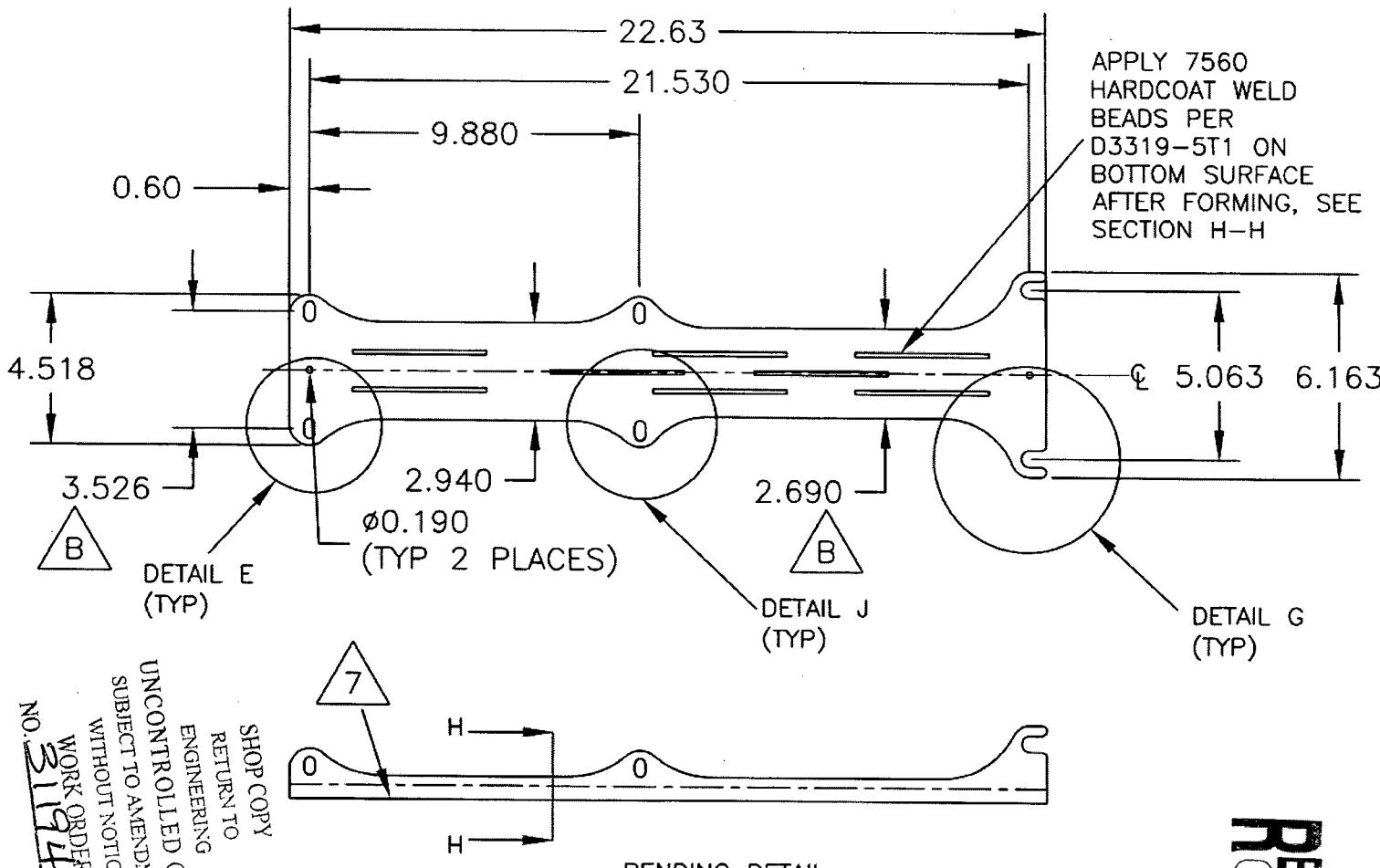
DART AEROSPACE LTD	
HAWKESBURY, ONTARIO, CANADA	
DESIGN <i>PF</i>	DRAWN BY <i>PF</i>
CHECKED <i>PF</i>	APPROVED <i>PF</i>
DRAWING NO. D3319	
TITLE WEARPLATE	
SHEET 2 OF 5	
SCALE 1:15	
REV. B	
DATE	05.06.06



DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
REV. B	SHEET 3 OF 5	SCALE
DATE	TITLE	1:5
05.06.06	WEARPLATE	
CHECKED	APPROVED	DRAWN BY
<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>

RE
LE
AS
ED
05-09-30

FLAT PATTERN

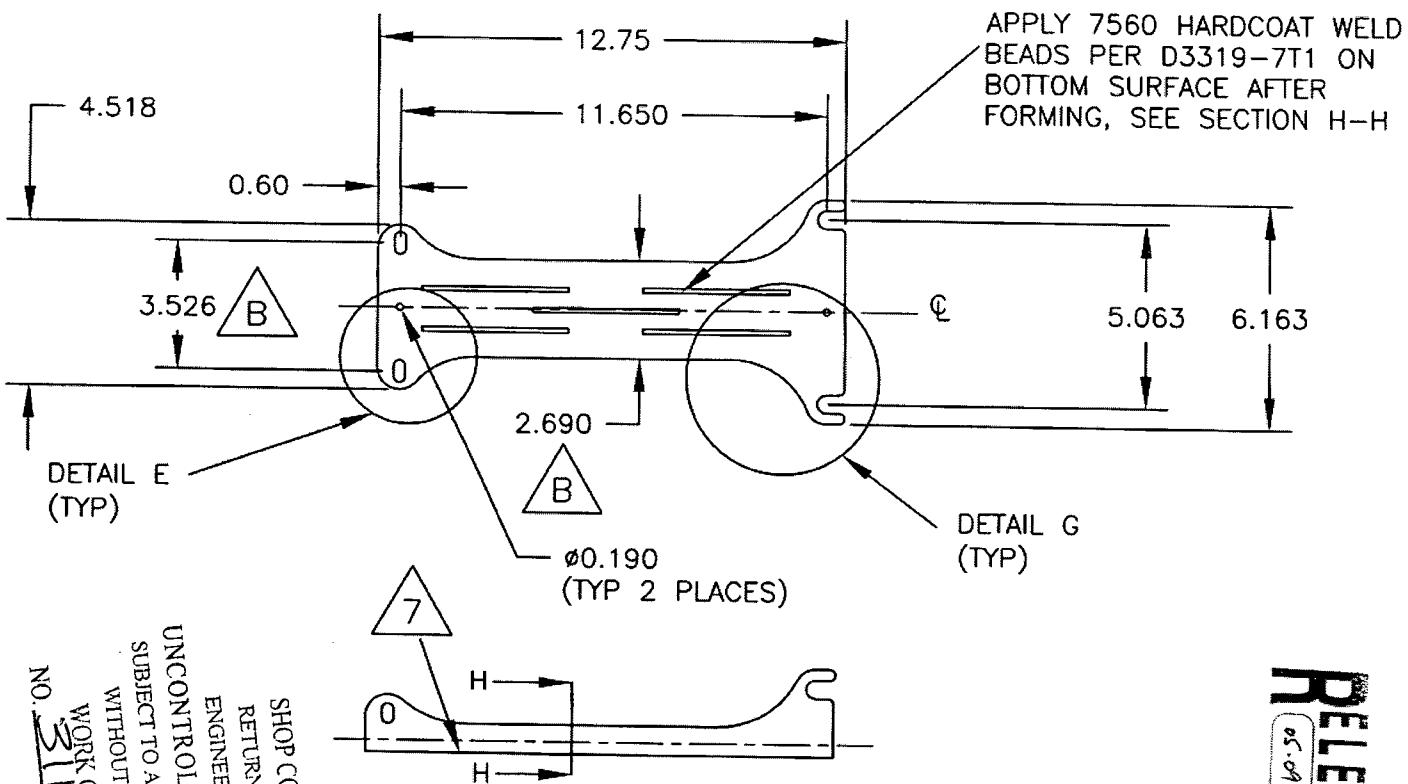


D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DART

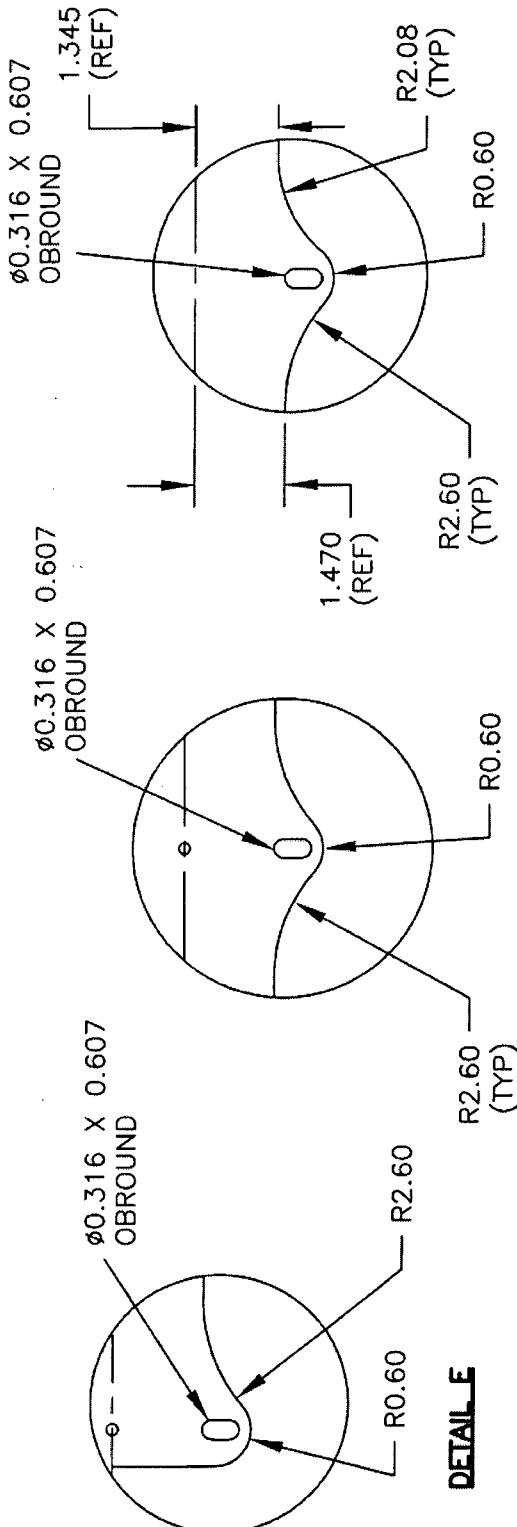
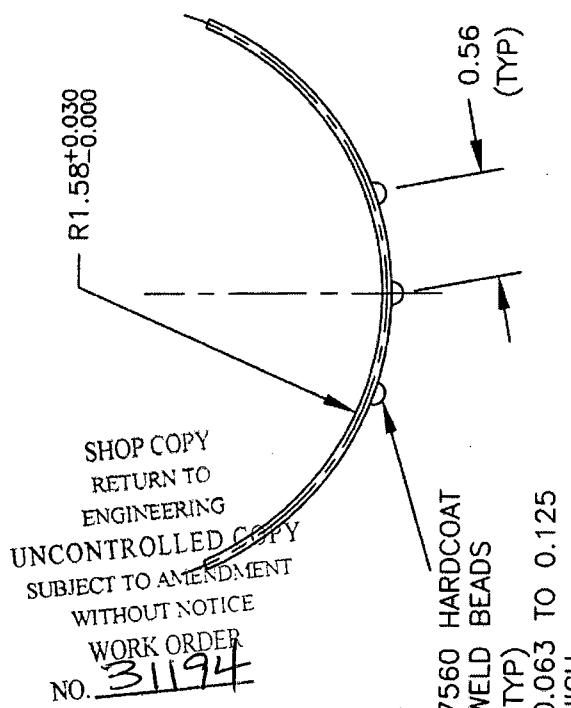
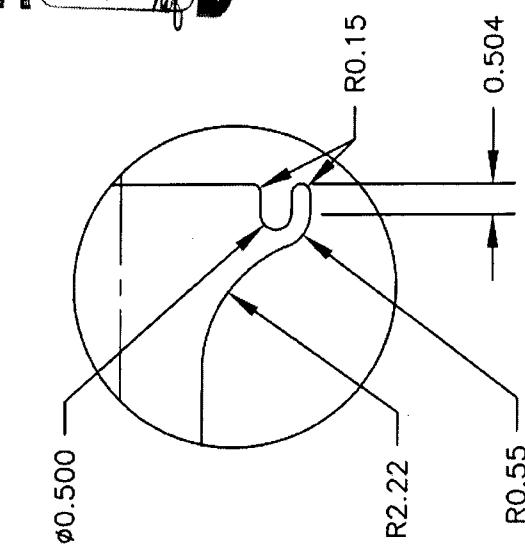
DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD	
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3319	REV. B
DATE 05.06.06	TIME	WEARPLATE	SHEET 4 OF 5
SCALE 1:5			

RELEASED
05.06.06FLAT PATTERNBENDING DETAILD3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06		TITLE WEARPLATE	SCALE 1:3

**RELEASED**
05.09.30/07

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DART AEROSPACE LTD

Work Order: 31194

Description: WEARPLATE

Part Number: D33191

Inspection Dwg: D3319 Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 4.984	+/- 0.010	4.982	✓		Vern	
B 3.815	+/- 0.010					
C 1.600	+/- 0.010	1.608	✓		Vern	
D 2.660	+/- 0.010	2.669	✓		Vern	
E 3.190	+/- 0.010	3.199	✓		Vern	
F 3.563	+/- 0.010	3.558	✓		Vern	
G 4.712	+/- 0.010	4.712	✓		Vern	
H 0.60	+/- 0.030	0.61			Vern	
I 10.576	+/- 0.010	10.571	✓		Vern	
J 11.942	+/- 0.010	11.949	✓		Vern	
K 16.100	+/- 0.010	16.100	✓			H4
L 18.09	+/- 0.030	18.09	✓		Vern/M-T	
M Ø0.316 x 0.546	+/- 0.010	0.311 x 0.549	✓		Vern	
N Ø0.316 x 0.670	+/- 0.010	0.310 x 0.672	✓		Vern	
O Ø0.190	+/- 0.005	Ø0.190	✓		Vern	
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by:	SAD	Audited by:	ZG	Prototype Approval:	PT N/A
Date:	07/05/09	Date:	07-05-09	Date:	07-05-09 N/A

Rev	Date	Change	Revised by	Approved
J		New Issue	KJ/RF	

